

MAR 25 2008

Application No. 10/540,354
After Final Office Action of January 25, 2008

Docket No.: 209546-98123

AMENDMENTS TO THE CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (Currently Amended) A method for manufacturing a work piece, the method comprising the steps of:

- providing a low-pressure mold tool including a first half and a second half, wherein one of the first and second halves includes a runner that terminates at a gate, wherein the low pressure mold tool defines a cavity;
- formulating an in-mold coating to include a mold release agent;
- introducing the ~~an~~ in-mold coating onto one of the first and second mold halves;
- introducing through the runner and out of the gate a work piece material onto said cavity, wherein the work piece material includes a temperature at or above a temperature at which at least a portion of the work piece material is in a molten state;
- closing the mold tool;
- bonding the in-mold coating with the work piece material and forming a work piece including an integral class "A" surface, wherein the class "A" surface is defined by the in-mold coating; and
- opening the low pressure mold tool and removing the work piece after the work piece material has at least partially cooled, ~~wherein the above steps are conducted in one cycling operation.~~

2. (Previously presented) A method for manufacturing a work piece according to Claim 1, wherein the in-mold coating is introduced by spraying the in-mold coating onto one of the first and second mold halves.

3. (Original) A method for manufacturing a work piece according to Claim 1, wherein the work piece material comprises a thermoplastic resin material.

Application No. 10/540,354
After Final Office Action of January 25, 2008

Docket No.: 209546-98123

4. (Previously presented) A method for manufacturing a work piece according to Claim 3, wherein the work piece material comprises Polypropylene (PP), Acrylnitril-Butadiene-Styrene-Copolymer (ABS), Polycarbonate-Acrylnitril-Butadien-Styrol-Copolymer (PC/ABS), or Thermoplastic Olefin (TPO) material.

5. (Original) A method for manufacturing a work piece according to Claim 1, wherein the work piece material includes fillers, reinforcement glass or reinforcement natural fibers.

6-8. (Cancelled)

9. (Previously presented) A method for manufacturing a work piece according to Claim 1, wherein the closed mold tool exerts a pressure of approximately 0.5 to 2.0 tons per square inch.

10. (Cancelled)

11. (Previously presented) A method for manufacturing a work piece according to Claim 2, wherein the spraying of the in-mold coating further comprises the step of airlessly atomizing the in-mold coating.

12. (Previously presented) A method for manufacturing a work piece according to Claim 2, further comprising the step of
masking said work piece by
spraying a second in-mold coating different from said first in-mold coating onto
said one of the first and second mold halves.

Application No. 10/540,354
After Final Office Action of January 25, 2008

Docket No.: 209546-98123

13. (New) A method for manufacturing a work piece, the method comprising the steps of:

- providing a low-pressure mold tool including a first half and a second half, wherein one of the first and second halves includes a runner that terminates at a gate, wherein the low pressure mold tool defines a cavity;
- spraying an in-mold coating onto one of the first and second mold halves by airlessly atomizing the in-mold coating;
- introducing through the runner and out of the gate a work piece material onto said cavity, wherein the work piece material includes a temperature at or above a temperature at which at least a portion of the work piece material is in a molten state;
- closing the mold tool;
- bonding the in-mold coating with the work piece material and forming a work piece including an integral class "A" surface, wherein the class "A" surface is defined by the in-mold coating; and
- opening the low pressure mold tool and removing the work piece after the work piece material has at least partially cooled.

Application No. 10/540,354
After Final Office Action of January 25, 2008

Docket No.: 209546-98123

14. (New) A method for manufacturing a work piece, the method comprising the steps of:

- providing a low-pressure mold tool including a first half and a second half, wherein one of the first and second halves includes a runner that terminates at a gate, wherein the low pressure mold tool defines a cavity;
- introducing a first in-mold coating onto one of the first and second mold halves;
- introducing a second in-mold coating different from said first in-mold coating onto said one of the first and second mold halves;
- introducing through the runner and out of the gate a work piece material onto said cavity, wherein the work piece material includes a temperature at or above a temperature at which at least a portion of the work piece material is in a molten state;
- closing the mold tool;
- bonding the first and second in-mold coatings with the work piece material and forming a work piece including an integral class "A" surface, wherein the class "A" surface is defined by the first and second in-mold coatings; and
- opening the low pressure mold tool and removing the work piece after the work piece material has at least partially cooled.